

Work Order ID 155577

Tuesday, January 17, 2017 11:27:42 AM

155577

Page 1

Item ID: D2989-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Lid Aft
Start Date: 1/12/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/17/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JAN 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100

0.00

100

Large Fab

Large Fab

Memo

0.38

Large Fab

- 1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: 4136695

1x CC 17-3-15

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

① 17-03-15 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 2

Hand Finishing

DAS
9
9-8

34

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 155577

Tuesday, January 17, 2017 11:27:42 AM

155577

Page 3

Item ID: D2989-043

Revision ID:

Item Name: Basket Lid Aft

Start Date: 1/12/2017 Start Qty: 1.00

Required Date: 1/17/2017 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel

0.00

130

Powdercoat

Powder Coating

Memo

1- Plug holes prior to powder coating

0.04

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per OSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

1 17-03-00 333

DAS
33
9-09

MAR 22 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
238				Completed By	
				Lead hand / Supervisor Approval Verification	
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Work Order ID 155577

Tuesday, January 17, 2017 11:27:42 AM

155577

Page 4

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Revision ID:

Item Name: Basket Lid Aft

Start Date: 1/12/2017 Start Qty: 1.00

Required Date: 1/17/2017 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: W6

0.00

0350-607-043 / 3157142

12 4 2103/12***150***

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

17/3/23 MF***160***

QC

Memo

0.02

Quality Control

MF
17-3-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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155577

D2989-043

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1		Manufactured	No			100	Each	6.0000	1	1			
D2221-1									**B157565→1x			DAS 43 MAR 12 2017	
Rib												9-89	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA004				6					
					129923			1					
					149891			5					
D2989-3		Manufactured	No			100	Each	0.0000	1	1			
D2989-3									**B157949→1x			DAS 43 MAR 12 2017	
Rib												9-89	
D2989-4		Manufactured	No			100	Each	0.0000	1	1			
D2989-4									**B157948→1x			DAS 43 MAR 12 2017	
Rib												9-89	
D2989-5		Manufactured	No			100	Each	0.0000	2	2			
D2989-5									**B157968→1x			DAS 43 MAR 12 2017	
Rib												9-89	
D3182-1		Manufactured	No			100	Each	16.0000	2	2			
D3182-1									**B100864→2x			DAS 43 MAR 12 2017	
Hinge												9-89	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA004				16					
					100864			4					
					125192			12					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, January 17, 2017 11:27:41 AM

Page 2

Work Order ID: 155577

155577

Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Aft

Start Date: 1/12/2017

Required Date: 1/17/2017

Start Qty: 1.00

Required Qty: 1.00

D3442-3

Manufactured No

100

Each

27.0000

2 2

✓ ***D3442-3***
Shim

** B100273 → 2x DAS 43 9-89 MAR 12 2017

Location

Loc Qty

Loc Code

WA004

27

100273

15

126296

12

D3827-041

Manufactured No

100

Each

6.0000

1 1

✓ ***D3827-041***
Rib Assembly (Inboard)

** B146472 → 1x DAS 43 9-89 MAR 12 2017

Location

Loc Qty

Loc Code

WA004

6

146472

6

D3832-5

Manufactured No

100

Each

0.0000

1 1

D3832-5
Mesh (Lid)

** B 146485 MUF 17-3-23

D3833-5

Manufactured No

100

Each

10.0000

2 2

✓ ***D3833-5***
Mesh (Lid End)

** B127335 → 2x DAS 43 9-89 MAR 12 2017

Location

Loc Qty

Loc Code

WA004

8

127335

2

127336

2

127337

2

127338

2

WA006

2

100771

2

Tuesday, January 17, 2017 11:27:42 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Tuesday, January 17, 2017 11:27:42 AM

Page 3

Work Order ID: 155577

155577

Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Aft

Start Date: 1/12/2017

Required Date: 1/17/2017

Start Qty: 1.00

Required Qty: 1.00

D3838-041

Manufactured No

100

Each

3.0000

1

1

✓ ***D3838-041***

Rib Assembly (Basket Lid, LH)

****B118996 → 1x**

DAS
43
9-89

MAR 12 2017

Location

Loc Qty

Loc Code

WA004

3

101747

1

118996

2

D3838-042

Manufactured No

100

Each

3.0000

1

1

✓ ***D3838-042***

Rib Assembly (Basket Lid, RH)

****B125161 → 1x**

DAS
43
9-89

MAR 12 2017

Location

Loc Qty

Loc Code

WA004

3

101570

1

125161

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
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OTHER : ☐					

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155577 MJS
17-01-19

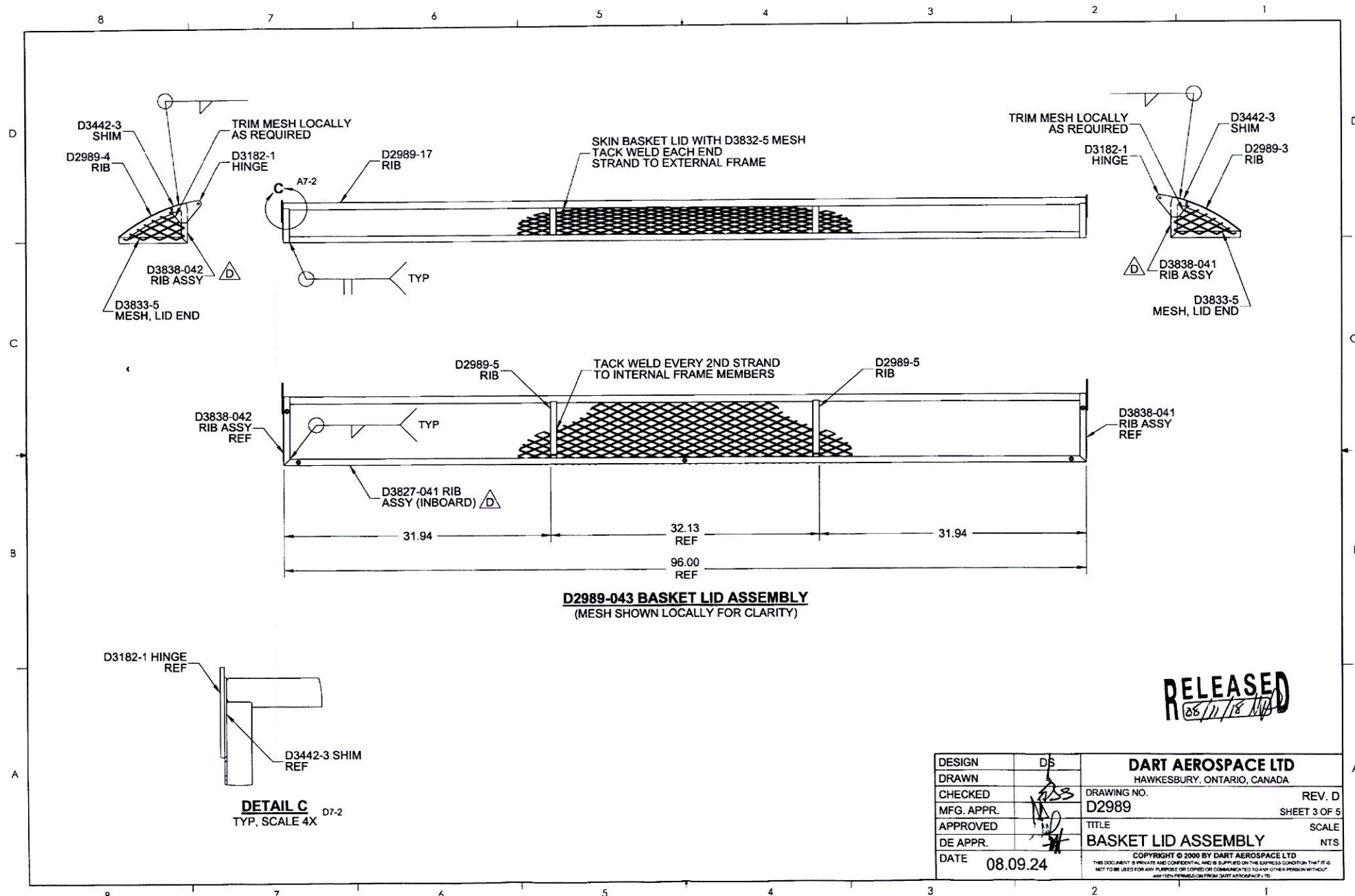
- NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

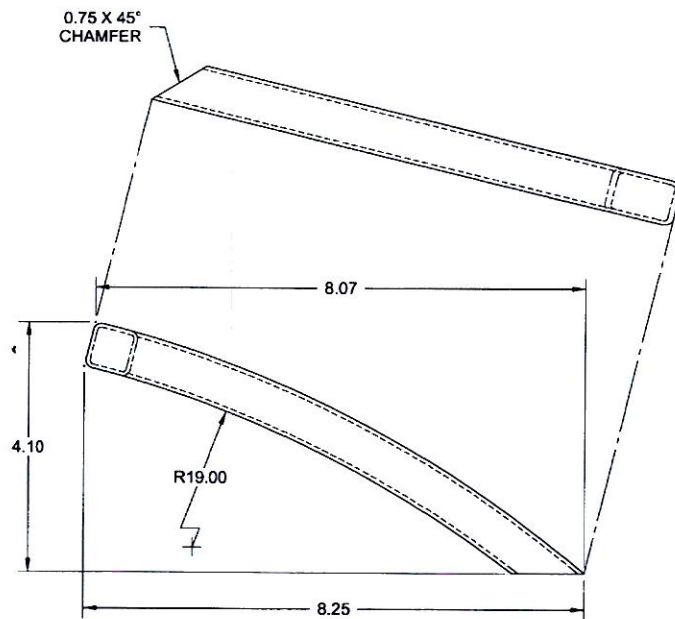
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D3827-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL, MESH MATERIAL UPDATED, DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	CS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

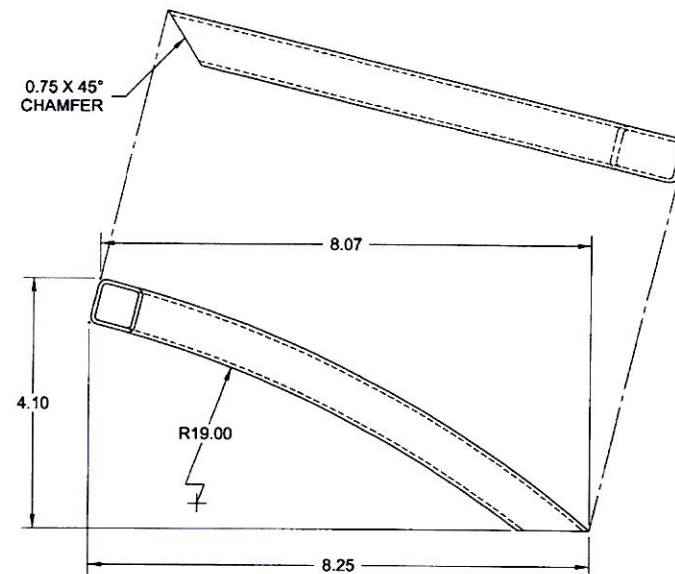
DRAWING NO. **D2989** REV. D
SHEET 1 OF 5
TITLE **BASKET LID ASSEMBLY** SCALE NTS

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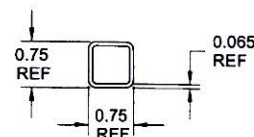




D2989-3 RIB



D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

